

Work Order ID 162429

Tuesday, June 06, 2017 4:57:33 PM

162429

Page*1

Item ID: D3500-1 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 6/9/2017 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 6/19/2017 Req'd Qty: 20.00 ***20*** Customer:

Reference: DAS
 Approvals: Process Plan: 21 Date: JUN 08 2017 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3500	C

100	HAAS CNC VERTICAL MACHINING #1	2.84				20	Ø		DAS 44 9-89 17-06-21
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100
 HAAS 1
 HAAS CNC vertical machine #1
 Memo
 Program Batch No. 162429 Double check by man 4-Machine Step No 1
 per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step
 No 2 per Folio FA641 and inspect per attached Dimension Sheets3-Machine
 Step No 3 per Folio FA641 and inspect p

110	QC1- Inspection performed by CMM	0.00				20	Ø		DAS 44 9-89 17-06-21
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110
 QC
 Quality Control
 Memo
 Inspect on CMM as per folio CMMA031.
 DWG REV: _____
 CMM PROG. REV: _____

120	QC8- Inspect parts - second check	0.00				20	Ø		DAS 14 9-89 17/06/26
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120
 QC
 Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 162429

Tuesday, June 06, 2017 4:57:33 PM

162429

Page 2

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle
Start Date: 6/9/2017 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 6/19/2017 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	1.11							
Hand Finishing									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140	M137176								
Powdercoat	Memo	0.62							
Powder Coating	START TIME: 7:50 FINISH TIME: 8:20								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.20							
Quality Control									

(X20) 20170703
BEB

20 170714 258

20 DAS 38 9-89

JUL 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 162429

Tuesday, June 06, 2017 4:57:33 PM

162429

Page 3

Item ID: D3500-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Saddle

Stop ***NS2***

Start Date: 6/9/2017 Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/19/2017 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: 51406	0.00							
160									
Packaging	Memo	0.20							
Packaging									

20
JUL 27 2017
DAS
6
9-89

170	QC21- Final Inspection - Work Order Release	0.00
170		
QC	Memo	2.00
Quality Control		

17/7/31

DAS
21
9-89

JUL 27 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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		OTHER : _____																																																																					

Picklist Print

Monday, June 05, 2017 4:53:49 PM

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Work Order ID: 162429

162429

Parent Item: D3500-1

D3500-1

Parent Item Name: Saddle

Start Date: 6/9/2017

Required Date: 6/19/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	21.0000	1	20			
D6102-013									**				
Saddle Billet													

DAS
44
9-89 **17-06-21**

Location

Loc Qty

Loc Code

MAT046

21

160144

21

161496

10

→ 10

DART AEROSPACE LTD		Work Order: 162429
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.378	.378	.378	.378	.378
F	0.490	0.510		.500	.500	.500	.500	.499
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.250	.250	.251	.251	.249
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.510	6.510	6.508	6.508	6.508
P	5.990	6.010		5.999	6.000	5.999	5.999	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.549	.550	.550	.550	.550
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.110	.110	.110	.110	.110
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.630	.630	.630	.630	.630
AD	0.240	0.260		.250	.252	.249	.250	.250
AE	1.810	1.830		1.821	1.821	1.823	1.820	1.820
AF	0.240	0.260		.248	.248	.248	.247	.248
AG	0.140	0.160		.151	.150	.150	.149	.150
AH	0.140	0.160		.153	.153	.151	.154	.153
AI	0.140	0.160		.152	.152	.153	.154	.152

DAS Accept/Reject

Measured by: 44	Date: 17-06-21
Audited by: 14	Date: 17/06/2021
Preliminary Approval: 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD		Work Order:	162429
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C DSK: ' Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.378	.378	.378	.378	.378
F	0.490	0.510		.500	.500	.500	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.251	.251	.251	.250	.250
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.508	6.507	6.507	6.508	6.508
P	5.990	6.010		5.999	5.999	5.999	5.998	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.550	.550	.550	.550	.550
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.110	.110	.110	.110	.110
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.630	.630	.630	.630	.630
AD	0.240	0.260		.248	.250	.250	.251	.249
AE	1.810	1.830		1.820	1.821	1.822	1.820	1.820
AF	0.240	0.260		.248	.248	.249	.250	.249
AG	0.140	0.160		.150	.150	.151	.150	.150
AH	0.140	0.160		.154	.152	.153	.151	.151
AI	0.140	0.160		.152	.153	.153	.152	.150

DAS Accept/Reject

Measured by:	44 9-69	DAS	Date:	17-06-22
Audited by:	14 9-59		Date:	17/06/26
Preliminary Approval:			Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD		Work Order: 162424
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.378	.378	.378	.378	.378
F	0.490	0.510		.500	.500	.500	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.251	.250	.251	.251	.251
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.508	6.508	6.508	6.508	6.508
P	5.990	6.010		5.998	5.998	5.998	5.999	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.550	.550	.550	.550	.550
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.110	.110	.110	.110	.110
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.630	.630	.630	.630	.630
AD	0.240	0.260		.250	.249	.250	.249	.250
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.821
AF	0.240	0.260		.247	.248	.247	.248	.248
AG	0.140	0.160		.150	.150	.149	.150	.150
AH	0.140	0.160		.151	.151	.151	.151	.150
AI	0.140	0.160		.151	.152	.153	.152	.151

DAS Accept/Reject

Measured by: 44	Date: 17-06-23
Audited by: 14	Date: 17/06/26
Preliminary Approval:	Date:

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A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD		Work Order:	162729
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16 1	17 2	18 3	19 4	20 5
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.378	.378	.378	.378	.378
F	0.490	0.510		.500	.500	.500	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.251	.251	.251	.252	.251
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.507	6.509	6.508	6.508	6.508
P	5.990	6.010		5.999	5.998	5.999	5.999	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.550	.550	.550	.550	.550
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.110	.110	.110	.110	.110
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.630	.630	.630	.630	.630
AD	0.240	0.260		.249	.251	.250	.250	.249
AE	1.810	1.830		1.821	1.821	1.821	1.821	1.821
AF	0.240	0.260		.247	.247	.248	.248	.248
AG	0.140	0.160		.149	.150	.150	.150	.150
AH	0.140	0.160		.151	.151	.151	.151	.151
AI	0.140	0.160		.151	.152	.152	.152	.151

Measured by:	44 0-00	DAS	Date:	17-06-23
Audited by:	14 9-00		Date:	17/06/26
Preliminary Approval:			Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
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D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

